

14

Date: Wednesday, 15/08/2007 4:07:20 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET
Jot Number	: 33968		
Estimate Number	: 12543		
P.C. Number	: N/A	Part Number	: D35381
This Issue	: 15/08/2007 S.O. No. : N/A	Drawing Number	: D3538 REV.A
Prsht Rev.	: NC	Project Number	: 10254N/A
First Issue	: N/A	Drawing Revision	: A
Previous Run	: 32371	Material	: N/A
Written By	: <u>J.F. 07/08/2016</u>	Due Date	: 31/08/2007
Checked & Approved By	: _____	Qty:	20 Um: Each
Comment	: Est Rev:A New Issue 06-10.03 EC		

Additional Product

Jot Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25"
	Comment: Qty.: 0.1995 f(s)/Unit- Total: 3.9900 f(s) 6061_T6 Bar 1.250" x 1.250 Batch: <u>M 104554</u>	
2.0	BAND SAW	BAND SAW
	Comment: BAND SAW Cut blanks 1.500" long	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: 1-Machine as per Folio FA651 and Dwg D3538 2-Deburr	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/08/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:07:20 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 33968

Part Number: D35381

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M 07-08-27 (20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 07/08/28

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CB 07/08/29 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 108

07/08/29 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/30 (20)

Job Completion



U 07-08-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

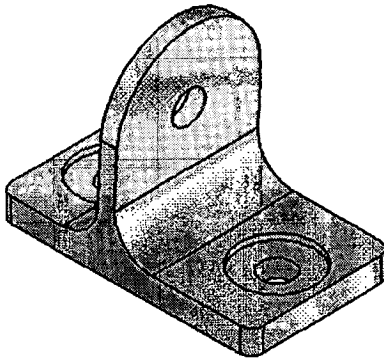
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

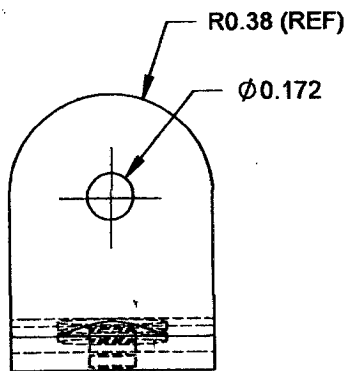
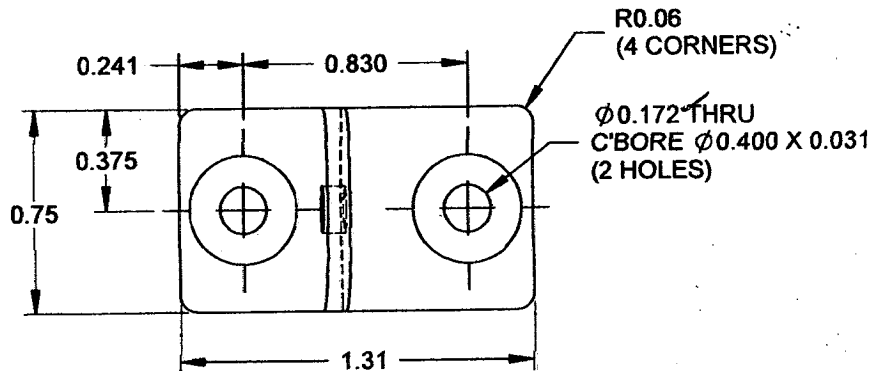
NOTE: Date & initial all entries



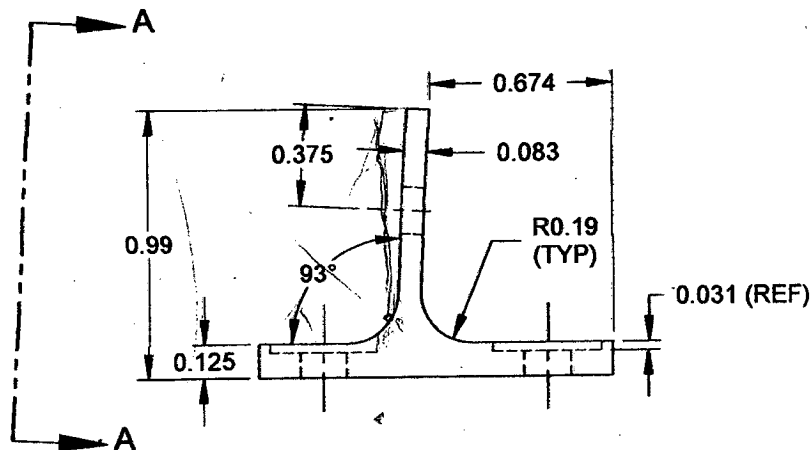
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3538	REV. A SHEET 1 OF 2
DATE 06.10.13	TITLE HINGE BRACKET	SCALE 1:1	
REV A	DATE 06.10.13	DESCRIPTION NEW ISSUE	



RELEASED
06.10.13



AUXILIARY VIEW A



D3538-1 HINGE BRACKET

NOTES:

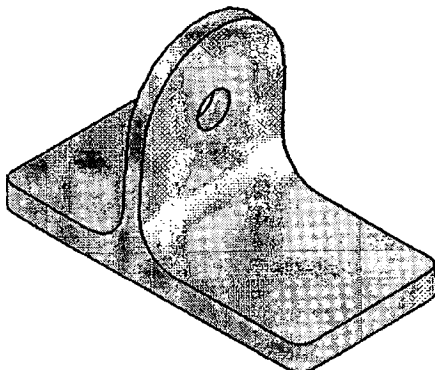
- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

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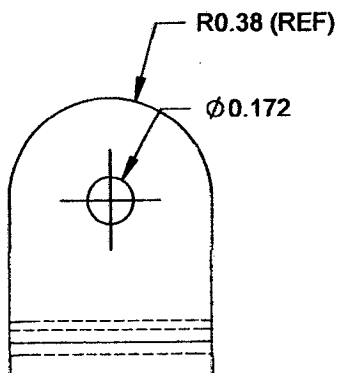
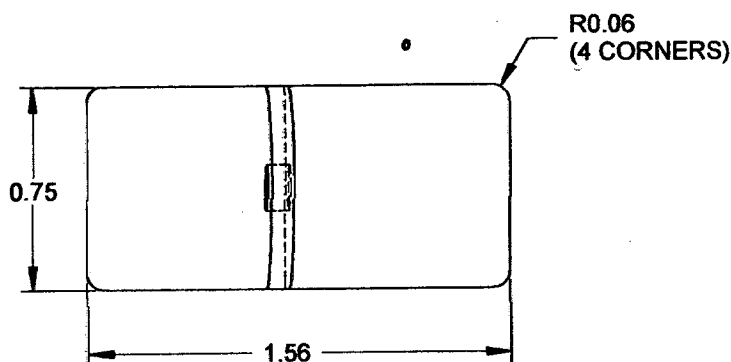
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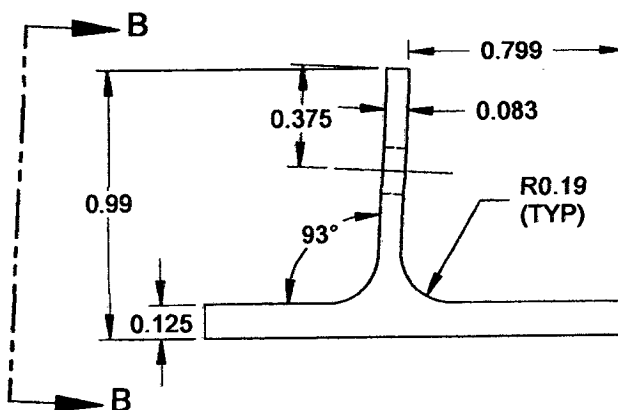
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3538	REV. A SHEET 2 OF 2
DATE 06.10.13	TITLE HINGE BRACKET		SCALE 1:1



RELEASED
06.10.13



AUXILIARY VIEW B



D3538-3 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

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DART AEROSPACE LTD		Work Order: 33968
Description: Hinge Bracket		Part Number: 03538-1
Inspection Dwg: 03538 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.830"	±.010"	.831"	✓			
.241"	±.010"	.244"	✓			
.375"	±.010"	.375"	✓			
.75"	±.030"	.755"	✓			
1.31"	±.030"	1.317"	✓			
R0.06"	±.030"	R.060"	✓			
Ø.172"	±.004"	Ø.175"	✓			
Ø.400"	±.010"	Ø.402"	✓			
.031" prof	±.010"	.033	✓			
A.38"	±.030"	A.380"	✓			
.99"	±.030"	.992"	✓			
.125"	±.010"	.126"	✓			
.375"	±.010"	.375"	✓			
.083"	±.010"	.087"	✓			
.674"	±.010"	.680"	✓			

Measured by: JF.	Audited by: J.F.	Prototype Approval:
Date: 07/08/25	Date: 07/08/26	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	